

# Work Order ID 73690

Tuesday, September 13, 2011 10:36:37 AM

Page 1

Item ID: D412-664-203

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Aft

Start Date: 9/13/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D412-664-243

E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 007

Subtotal

CHG W/S

Star MLJ 11-10-19  
SEE W/D CHG

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

JW

11-10-11

120

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00


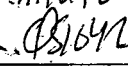
CNC Alpha 160 Bender

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

JW  
mo

11-10-11

D412-664-203 B 73690

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.10.18	150	KIT NOW CHG 008 PAPERWORK / LABELS SHOULD SAY CHG 008				 11.10.18 	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73690**

Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC15- Crosstube Dimensional Check

0.00

S 11/10/12

QC

Memo

0.00

Quality Control

C

140

Crosstubes

0.00

Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 &amp; DT8551 and drill table DT8577 using #9 holes as per QSI 10 to install towers.

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 &amp; DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-SCRIBE PART # &amp; BATCH #

4-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

JW 11-10-12  
MO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Customer:

Reference:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Crosstubes Chemical Conversion

0.00

MO  
JL

11/10/12



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

160 QC3- Inspect Part Finish

0.00

S 11/10/14



QC

Memo

0.00

Quality Control

170 QC5- Inspect part completeness to step on W/O

0.00

S 11/10/14



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 5

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Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

0.00



SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per DEO D412-664-243 and QSI 005 4.2

PRIME:

Start Time: \_\_\_\_\_

Finish Time: \_\_\_\_\_

PAINT:

Start Time: \_\_\_\_\_

Finish Time: \_\_\_\_\_

11-10-14

11-10-15

RT 11-10-15

220

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

11 10 17 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 73690



Page 6

Tuesday, September 13, 2011 10:36:37 AM

Item ID: D412-664-203

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 9/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

0.00



Crosstubes

Crosstubes

Memo

0.00

Assemble as per Dwg D412-664-203

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

★ SEE W/O CHG

2-Install support with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond Batch: 118843

Expiry Date: OCT 31 2013

3-Install chafing shield and clamps as per DEO D412-664-243 using installation jig DT9024 Torque clamps to 80-100 in lb.

A/R Proseal batch: 118234

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 / 10 / 19 (1)

W/O: 73690		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/10/18	276	INSTALL SUPPORT PER DEC D412-664-243-E-2	RT	11/10/18	1	11/10/18 PS/012	11/10/18 11/10/18

Part No: D412-664-203 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 73690**

Tuesday, September 13, 2011 10:36:37 AM

Page 7

Item ID: D412-664-203

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Aft

Start Date: 9/13/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/10/19

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/19

④

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-664-203  
\*\*\*\*\*Ensure tube is not packaged if curing time is less than 12 hrs, see step 27  
for application time & date \*\*\*\*\*  
Time & date of packaging: \_\_\_\_\_  
Location: \_\_\_\_\_

11/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73690**

Tuesday, September 13, 2011 10:36:37 AM



Page 8

Item ID: D412-664-203

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 9/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/19

ME  
11/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, September 13, 2011 10:36:43 AM

Page 1

Work Order ID: 73690

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft



Start Date: 9/13/2011

Required Date: 9/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.02.16 Reformat; Added D3189-1 K/DS  
 IPP Rev:F 06-03-29 Remove Comments on Pick List JLM  
 IPP Rev:G 06.12.08 per ECN 886 EC  
 IPP Rev:H 07-04-30 As per Rev D JLM  
 IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC IPP rev  
 G 11.04.21 DEO D412-664-243-E-1 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-664-203TRN 		Manufactured	No			110	Each	2.0000	1	1	JW	11-10-11	
Crosstube Turning Detail													

Location	Loc Qty	Loc Code
LG	2	
73071	1	
73072	1	

D2896-1 		Manufactured	No			230	Each	2.0000	1	1	RT	11-10-18	
Support													

Location	Loc Qty	Loc Code
LG052	2	
67742	2	

D3189-1 		Manufactured	No			230	Each	21.0000	2	2	RT	11-10-18	
Chafing Shield													

Location	Loc Qty	Loc Code
FG	4	
36065	4	
LG	1	
69576	1	
LG053	16	
70777	16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 13, 2011 10:36:44 AM

Work Order ID: 73690



Parent Item: D412-664-203



Parent Item Name: Crosstube Aft

Start Date: 9/13/2011

Required Date: 9/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3595-063-570

Manufactured No

230

Each

121.0000

2

2



RUBBER CUSHION



85 11-10-18

Location

Loc Qty

Loc Code

FG

8

37971

1

42243

7

LG

61

71534

61

LG055

52

42243

1

69735

51

x2

MS21920-28

Purchased

No

230

Each

60.0000

4

4



Clamp(per MIL-DTL-8783C)



85 11-10-18

Location

Loc Qty

Loc Code

FG

5

105884

5

LG050

55

116839

2

117998

4

118713

49

x4

MS21920-30

Purchased

No

230

Each

72.0000

2

2



clamp(per MIL-DTL-8783C)



85 11-10-18

Location

Loc Qty

Loc Code

LG050

50

117998

50

LG051

22

111258

22

x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, September 13, 2011 10:36:44 AM

Page 3

Work Order ID: 73690

Parent Item: D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 9/13/2011

Required Date: 9/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN6-40A

Purchased

No

250

Each

95.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST340

50

118422

50

ST343

45

117688

45

AN6-41A

Purchased

No

250

Each

50.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST344

50

117366

30

118451

20

AN960JD616

NAS1149D0663J

Purchased

No

250

Each

0.0000

18

18



Washer

MS21042L6

Purchased

No

250

Each

250.0000

6

6



Nut

Location

Loc Qty

Loc Code

ST300

250

117677

200

118384

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

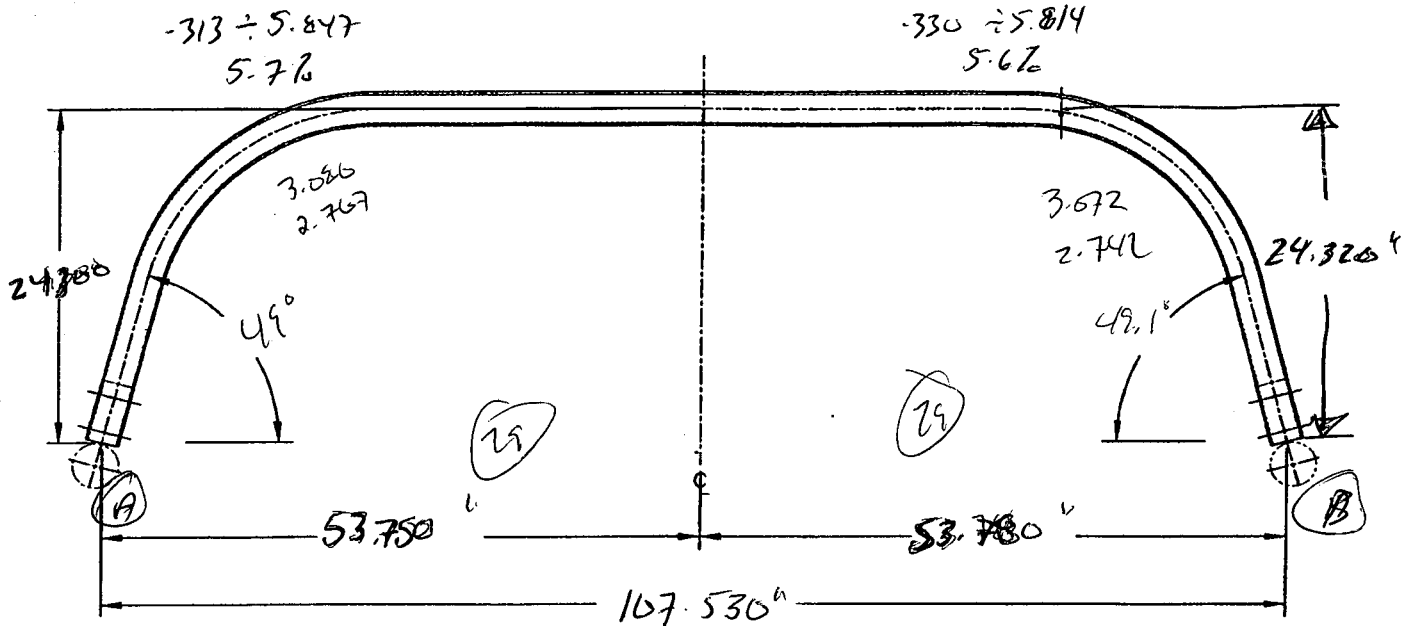
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	73690
Description: Crosstube High Aft (412)		Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
Size A = $5.776$ crushing @ 29 passes
Size B = $5.676$ crushing @ 29 passes.

QC15 Inspection	8
Date	undia.

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	
C	10.02.02	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Item	Qty -243	Part Number	Description
1	X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 47.0 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 3360  
11-09-13

DEO ATTACHED

RELEASED  
2009-10-29

E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398, MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. E
MFG. APPR.	PH	D412-664-243	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

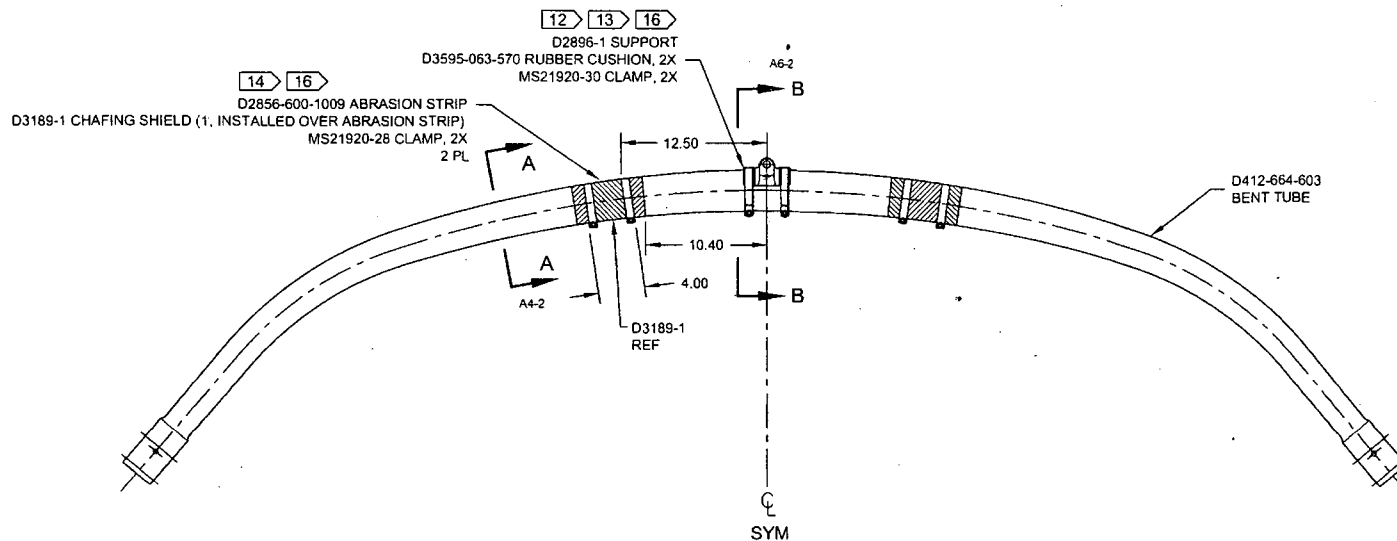
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

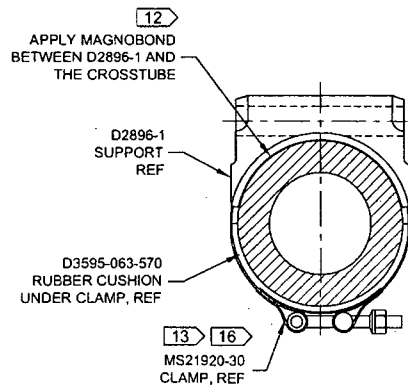
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

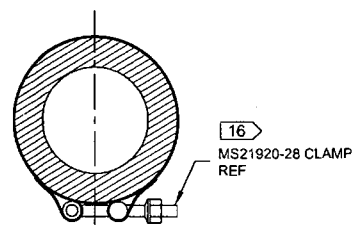
**NOTE:** Date & initial all entries



**D212-664-243**  
**ASSEMBLY DETAIL** E



**SECTION B-B** D4-2  
SCALE 4X



**SECTION A-A** C6-2  
SCALE 4X

DEO ATTACHED

**RELEASED**  
2009-10-29  
NKP

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. E
MFG. APPR.	18	D412-664-243	SHEET 2 OF 4
APPROVED	14	TITLE	SCALE
DE APPR.	14	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

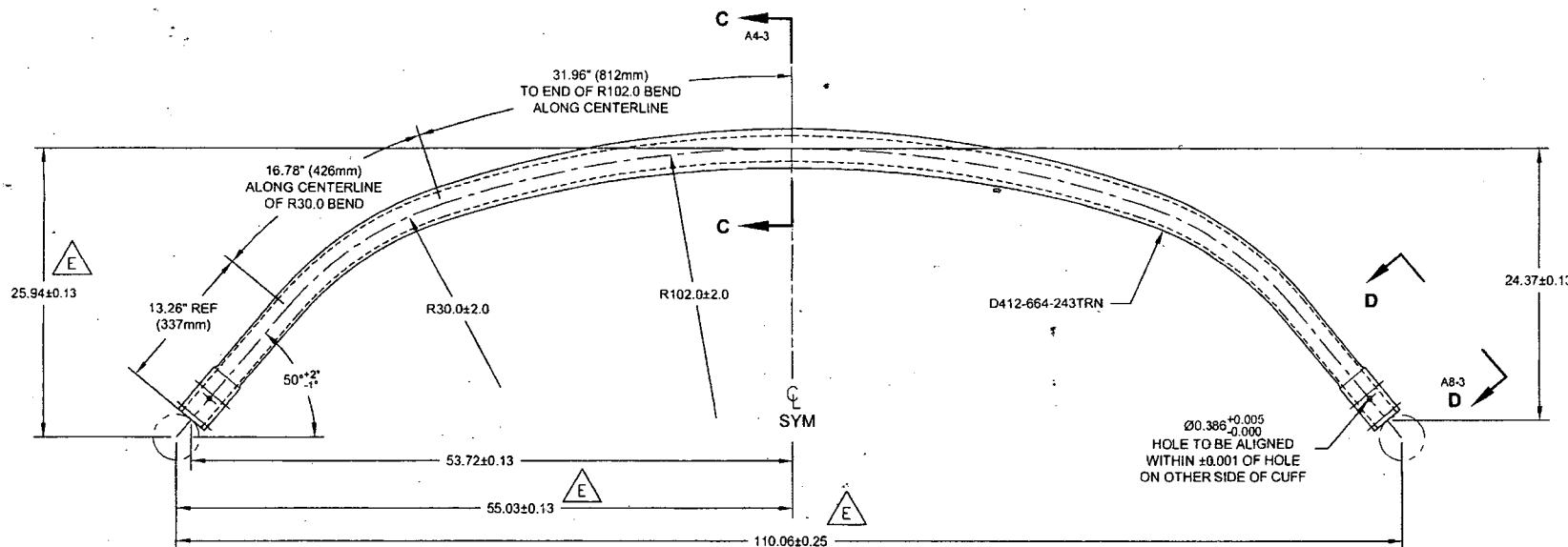
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

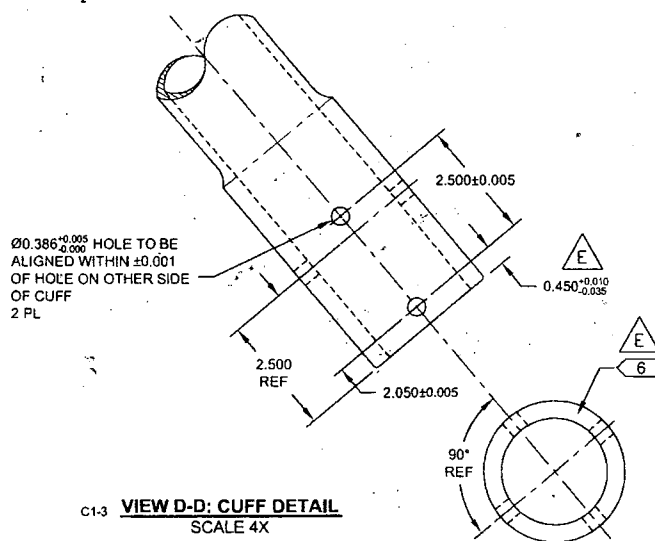
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

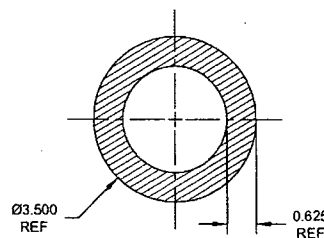
8 7 6 5 4 3 2 1



**D412-664-603** 10  
**BENDING AND DRILLING DETAIL** E



C1-3 **VIEW D-D: CUFF DETAIL**  
 SCALE 4X



**SECTION C-C** 05-3  
 SCALE 4X

72690

DEO ATTACHED

**RELEASED**  
 2009-10-29

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. E
MFG. APPR.	SS	D412-664-243	SHEET 3 OF 4
APPROVED	40	TITLE	SCALE
DE APPR.	4	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD                      THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

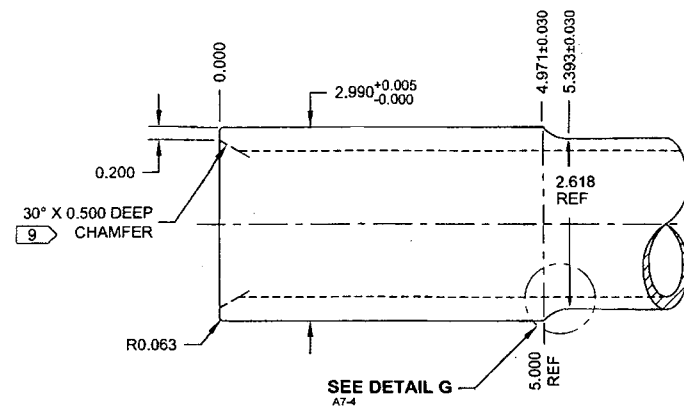
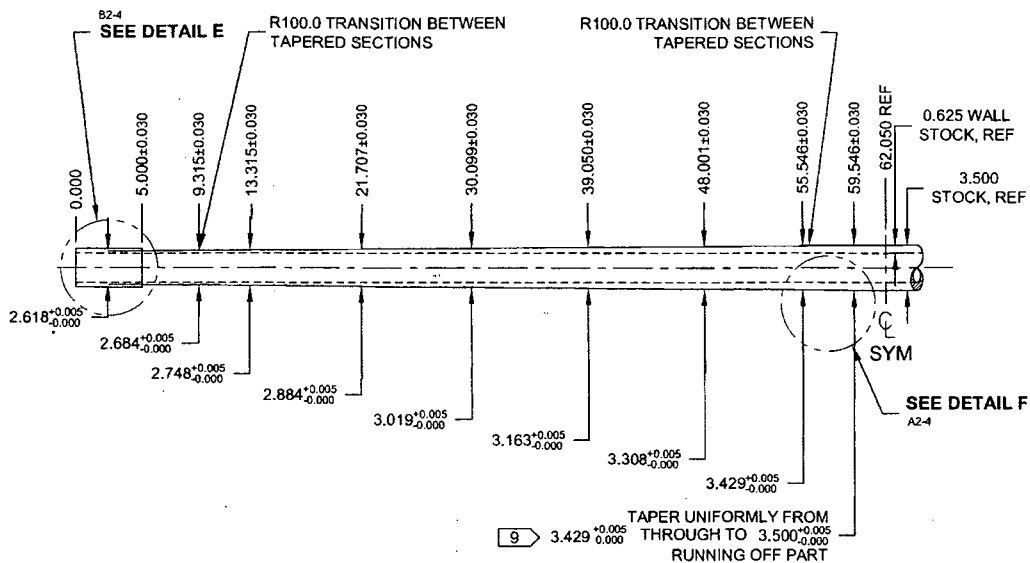
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

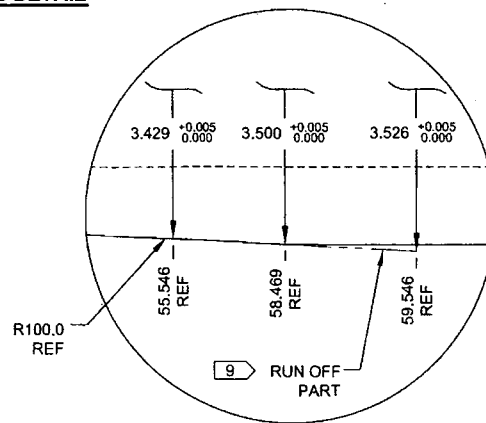
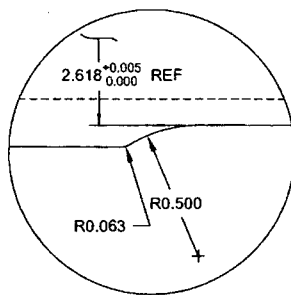
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D412-664-243TRN  
TURNING DETAIL**



73690

DEO ATTACHED

RELEASED

2009-10-29

DETAIL F:  
TAPER RUN-OFF C4-4  
NOT TO SCALE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QF	DRAWING NO.	REV. E
MFG. APPR.	AS	D412-664-243	SHEET 4 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	AL	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D412-664-243-E-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.			
DATE 11.03.31	DATE 11/03/31	DATE 11.03.31	DATE 11/03/31	DATE 11.03.31			

**PURPOSE:**

REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

**CHANGE:**

PARTS LIST IS AMENDED AS FOLLOWS:

**IS:**

Item	Qty -243	Part Number	Description
6	0	D2856-600-1009	ABRASION STRIP

**WAS:**

6	2	D2856-600-1009	ABRASION STRIP
---	---	----------------	----------------

NOTES 2 AND 14, SHEET 1 ARE AMENDED AS FOLLOWS:

**IS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA)  
PAINT OUTSIDE PER DART QSI 005 4.2  
AFTER PAINTING, APPLY CLEAR COAT ON HATCHED AREA
- 14) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3189-1  
CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL  
PROSEALED D3189-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF  
PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

**WAS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF  
CROSSTUBE PER QSI 035.

RELEASED  
2011-04-07  
MD

73690

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D412-664-243-E-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 11.03.31	DATE 11.03.31	DATE 11.03.31	DATE 11.03.31	DATE 11.03.31		

**IS:**

D3189-1 CHAFING SHIELD (1, INSTALLED OVER PROSEAL 890)  
MS21920-28 CLAMP, 2X  
2 PL

D412-664-603  
BENT TUBE

2.00  
1.00

**WAS:**

D2856-600-1009 ABRASION STRIP  
D3189-1 CHAFING SHIELD (1, INSTALLED OVER ABRASION STRIP)  
MS21920-28 CLAMP, 2X  
2 PL

D3189-1  
REF

**D412-664-243  
ASSEMBLY DETAIL**

2  
MASK AREA PRIOR TO PAINTING AND  
APPLY CLEAR COAT AFTER PAINTING

2.00

Q  
SYM

RELEASED  
2011-04-07  
*[Signature]*  
73690

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASS'Y (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D412-664-243-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 92	CHECKED ASS	MFG. APPR. RE	APPROVED MP		DE APPR. H		
DATE 11.09.07	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19		DATE 11.09.19		

**PURPOSE:**

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

**CHANGE:**

IS:

Item	Qty -243	Part Number	Description
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 16, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) INSTALL D2896-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.**

WAS:

- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**RELEASED**  
2011-09-29  
MP



## LIQUID PENETRANT TEST REPORT

P- 05634

CLIENT DART AEROSPACE DATE OCT-14-2011 PAGE 1 OF 1  
ATTENTION LYNDA / CHARLIE / VAN / MATT ACUREN JOB NO. 188-11-02196 TIME AM ☒ PM ☐  
ADDRESS 1270, ABERDEEN ST. POWO NO. 15157  
HAWKESBURY, ON WORK LOCATION AS ADDRESS  
PROJECT PT -> WET FLUORESCENT LIQUID PENETRANT O.D. 'CROSSTUBES' ACCEPTANCE STD. ASTM F47/CST 033 REV./DATE 2005  
ITEM(S) EXAMINED SEE BELOW

JOB DESCRIPTION PROCEDURE NO. LT 002 REV./DATE 2007 TECHNIQUE NO. LT-002 REV./DATE 2007  
PART NO. MATERIAL ALUMINUM THICKNESS  
SCOPE PERFORMED A WET FLUORESCENT LIQUID PENETRANT INSPECTION ON 100% OF THE EXTERNAL SURFACE ON ITEMS MENTIONED BELOW

TEST DETAILS  
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED  
FAMILY BRAND MAQUA FLUX BLACK LIGHT S/N 13798 OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☐ AMBIENT < 2  $^{\circ}$ C  
PENETRANT ZL-67 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE  
PENETRANT REMOVER H<sub>2</sub>O MINIMUM DRY TIME > 10 MIN. OTHER  
DEVELOPER SKD-52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE Aug-2011  
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE  
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL  
SURFACE TEMPERATURE ☐ < - 4 $^{\circ}$ C / 20 $^{\circ}$ F ☐ - 4 $^{\circ}$ C / 20 $^{\circ}$ F TO 10 $^{\circ}$ C / 50 $^{\circ}$ F ☒ 10 $^{\circ}$ C / 50 $^{\circ}$ F TO 52 $^{\circ}$ C / 125 $^{\circ}$ F ☐ > 52 $^{\circ}$ C / 125 $^{\circ}$ F

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM ID	DESCRIPTION	STATUS
1	CROSSTUBE W.O ID 72417	✓
2	72418	✓
3	73642	✓
4	73690	✓
5	73691	✓
6	74330	✓
7	74686	✓
8	74687	✓

NO RELEVANT INDICATION WAS DETECTED AS PER APPLICABLE STANDARDS.

RT 11-10-14

Scope of Services  
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES  
CLIENT REPRESENTATIVE Jan T. Hey DTR # E 44768  
TECHNICIAN (SIGNATURE): James Desrochers REPORT REVIEWED BY:  
NAME (PRINT): James Desrochers NAME INITIALS  
CGSB LEVEL 2 SNT LEVEL 3 CGSB LEVEL 2 SNT LEVEL 3  
CGSB REG. NO. 3049 CGSB REG. NO. 3049

# Location/Lot Activity

Thursday, March 29, 2012 12:36:44 PM

Page 1 of 3

Criteria : All Items All Locations Lot: 71502 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Account Value Change	D2896-1 / Support	Main Warehouse		FAUT01		20.0000		20.0000		
		LG			10/19/2011	-20.0000	71502	-20.0000		(\$6,397.93)
		Main Warehouse		FAUT01		20.0000		20.0000		
		LG			10/19/2011	20.0000	71502	20.0000		\$6,397.93
								<b>0.0000</b>		<b>\$0.00</b>
Inv Adjustment	D2896-1 / Support	Main Warehouse	Found	FAUT01		21.0000		0.0000		
		LG053			3/7/2012	1.0000	71502	1.0000		\$319.90
		Main Warehouse	Found	FAUT01		21.0000		0.0000		
		LG053			3/7/2012	1.0000	71502	1.0000		\$319.90
		Main Warehouse	B/N correction	GOLD01		21.0000		0.0000		
		LG053			3/23/2012	1.0000	71502	1.0000		\$319.90
		Main Warehouse	B/N correction	GOLD01		21.0000		0.0000		
		LG053			3/27/2012	1.0000	71502	1.0000		\$319.90
								<b>4.0000</b>		<b>\$1,279.59</b>
Issue	D2896-1 / Support	Main Warehouse	73691	QUIR01		20.0000		20.0000		
		LG			10/19/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	73690	QUIR01		19.0000		19.0000		
		LG			10/19/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	75417	QUIR01		18.0000		18.0000		
		LG			11/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	75416	QUIR01		17.0000		17.0000		
		LG			11/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	74376	FAUT01		16.0000		16.0000		
		LG			11/21/2011	-1.0000	71502	-1.0000		(\$319.90)

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D2896-1 / Support	Main Warehouse	74377 -203	FAUT01		15.0000		15.0000		
		LG			11/21/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	76351 -203	DESJ02		35.0000		14.0000		
		LG053			12/6/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	76350 -203	DESJ02		34.0000		13.0000		
		LG053			12/6/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	77108 -203	DESJ02		33.0000		12.0000		
		LG053			12/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	77273 -203	LAVO01		32.0000		11.0000		
		LG053			12/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	77109 -203	DESJ02		31.0000		10.0000		
		LG053			12/13/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	77433	QUIR01		30.0000		9.0000		
		LG053			12/19/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	77434	QUIR01		29.0000		8.0000		
		LG053			12/20/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	77748	FAUT01		28.0000		7.0000		
		LG053			1/6/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	77533	FAUT01		27.0000		6.0000		
		LG053			1/6/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	77534	FAUT01		26.0000		5.0000		
		LG053			1/6/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	78576	FAUT01		25.0000		4.0000		
		LG053			2/22/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	78574	FAUT01		24.0000		3.0000		
		LG053			2/22/2012	-1.0000	71502	-1.0000		(\$319.90)



Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D2896-1 / Support	Main Warehouse LG053	78575	FAUT01		23.0000		2.0000		
					2/22/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse LG053	78573	GOLD01		22.0000		1.0000		
					2/24/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse LG053	80135	FAUT01		22.0000		1.0000		
					3/7/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse LG053	80134	FAUT01		22.0000		1.0000		
					3/7/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse LG053	80585	GOLD01		22.0000		1.0000		
					3/23/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse LG053	80584	GOLD01		22.0000		1.0000		
					3/27/2012	-1.0000	71502	-1.0000		(\$319.90)
								-24.0000	(\$7,677.51)	
Loc Transfer	D2896-1 / Support	Main Warehouse LG053		GOLD01		0.0000		0.0000		
					11/30/2011	14.0000	71502	14.0000		\$4,478.55
		Main Warehouse LG		GOLD01		14.0000		14.0000		
					11/30/2011	-14.0000	71502	-14.0000		(\$4,478.55)
								0.0000	\$0.00	
WIP Receipt	D2896-1 / Support	Main Warehouse LG	71502	GOLD01		0.0000		0.0000		
					10/3/2011	20.0000	71502	20.0000		\$6,397.93
								20.0000	\$6,397.93	